

Work Order ID 139643

Monday, November 30, 2015 11:09:15 AM

139643

Page 1

Item ID: D3200-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Post Block
 Start Date: 12/31/2015 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 12/31/2015 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: DEC 03 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3200	Rev A								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 2.700" x 2.700								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.05							
HAAS CNC vertical machine #1	1-Machine D3200-1 as per Folio FA337 and Dwg D32002-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

15 2 15/12/16
 15 2 16-1-14
 DAS
 45
 2016-01-13

216-1-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor Approval Verification		
QC / QA Coordinator Approval								

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

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Monday, November 30, 2015 11:09:16 AM

139643

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						15	0		DAS 44 16/01/14 9-89
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: ST02SA	0.00				15			
140									DAS 6 9-89
Packaging	Memo	0.00							JAN 15 2016
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150						ML5			JAN 15 2016
QC	Memo	0.02							
Quality Control									

ML5 JAN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;"> OTHER : _____ </td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				Misidentified ☐	Past Due ☐
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Picklist Print

Monday, November 30, 2015 11:09:15 AM

Page 1

Work Order ID: 139643

139643

Parent Item: D3200-1

D3200-1

Parent Item Name: Door Post Block

Start Date: 12/31/2015

Required Date: 12/31/2015

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	446.4000	0.05	0.789474			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

15/12/16

Location

Loc Qty

Loc Code

MAT018

446.4

m133248

46.4

m133642

400

M131661

0.790

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause				FAULT CATEGORY			
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				OTHER : ☐			

DART AEROSPACE LTD		Work Order: 139643
Description: Door Post Block		Part Number: D3200-1
Inspection Dwg: D3200	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	.196	/		VERN	SL-10
0.405 x 100°	+/-0.010	.405 X 100°	/			
R0.100	+/-0.010	.100	/			
R0.130	+/-0.010	.130	/			
1.630	+/-0.005	1.630	/			
0.440	+/-0.030	.438	/			
2.500	+/-0.010	2.501	/			
1.845	+/-0.010	1.835	/			
0.015 - 0.050	N/A	.040	/			
1.000	+/-0.010	1.000	/			
1.620	+/-0.005	1.620	/			
2.500	+/-0.030	2.500	/			
0.750	+/-0.030	.754	/			

DAS

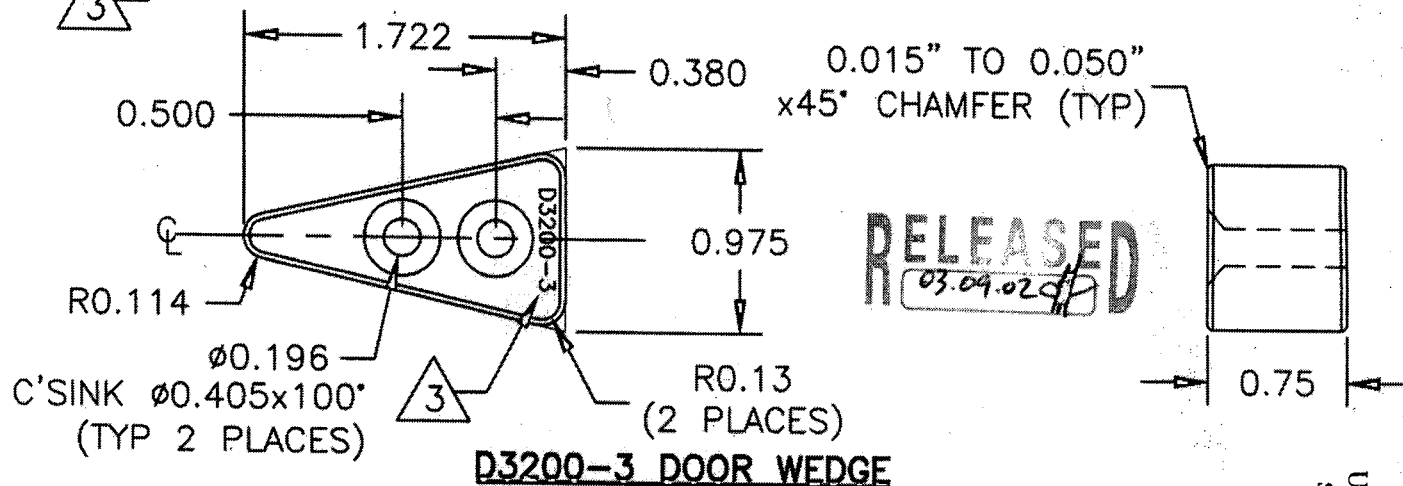
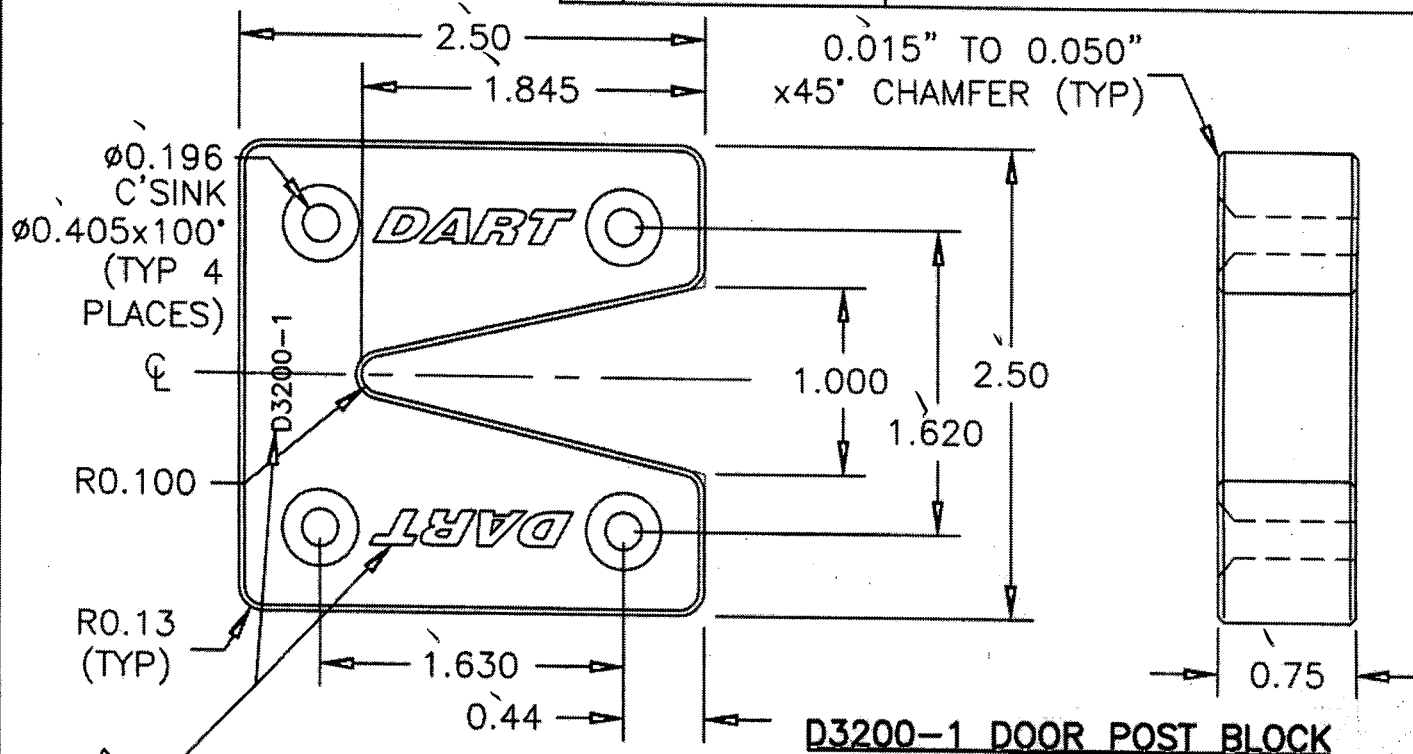
44
9-89

Measured by: SL	Audited by: DAS	Prototype Approval:	N/A
Date: 16-1-13	Date: 15/01/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D412-698-015	KJ/RF	JH



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOWN ON 1
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13264/3
15-2-03

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